Work Order ID 109508

November-21-13 2:33:13 PM

109508

Item ID: D2037-101 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Arm

Start Date: 11/21/13 **Start Qty:** ~~2.00~~ 4 *2*

Required Date: 11/21/13 **Req'd Qty:** 2.00 *2*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 13-11-22 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2037	D								13/11/26
100		0.00			DAS 30 9-89				
100	NC BRAKE					4			
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1								
110		0.00							
110	Small Fab					4			FF 13-12-11
Small Fab	**Memo**	0.00							
Small Fab	1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 ends of D2037-101 tube as required using DT8545		2-Flatten						
	3-Deburr as required								
120	QC5- Inspect part completeness to step on W/O	0.00							
120						4			
QC	**Memo**	0.00			DAS 27 9-89				
Quality Control									13/12/16

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D2037-101 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Arm
Start Date: 11/21/13 **Start Qty:** 2.00 *2* **Cust Item ID:**
Required Date: 11/21/13 **Req'd Qty:** 2.00 *2* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: N/A 0051	0.00							
130						4	0	13-12-16	
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

RM 13/12/30

MF
13-12-20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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☐ Bend
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☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

November-21-13 2:33:13 PM

Work Order ID: 109508

Parent Item: D2037-101

Parent Item Name: Arm

Start Date: 11/21/13 **Required Date:** 11/21/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:A New Issue 05-11-01 JLM
IPP Rev:B 08-07-29 revD as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			110	f	337.8490	**3.916**	**8.2442106**	DASS 30 8-89	13/11/26	

Location	Loc Qty	Loc Code	
MAT017	337.849018		
122312	10.8		
124768	55.31245		
M126183	238.620001		20
M126349	33.116567		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

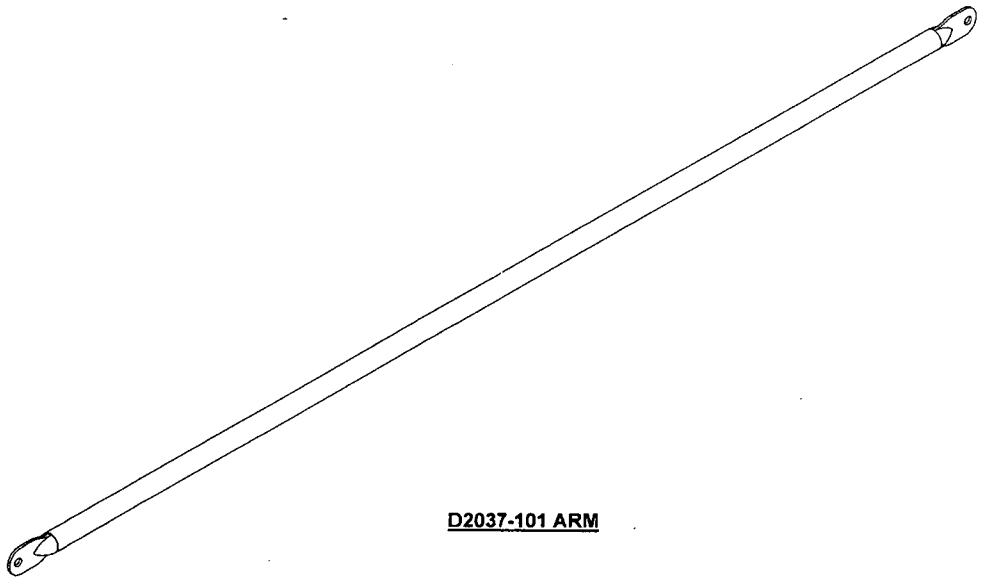
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☐ Wrong Stock Pulled
☐ Other _____



D2037-101 ARM

109508 MCJ
13-11-22

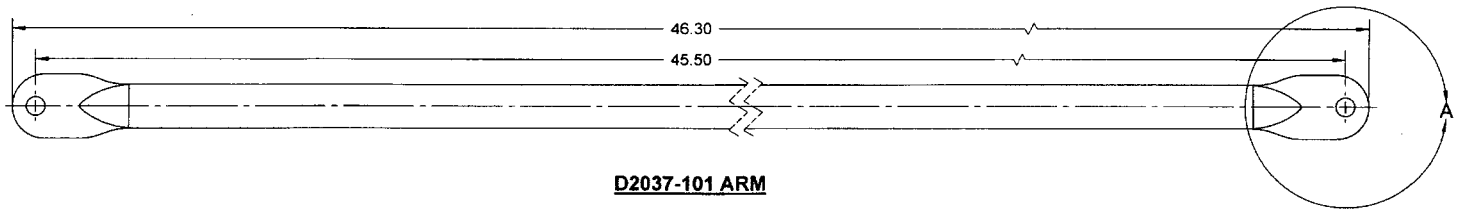
RELEASED
08.07.07

NOTES:
1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, ∅0.750 x 0.049 WALL
REF. DART SPEC M304TR0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.50 lbs
8) FOR FURTHER INFO SEE DRAWING D2638.

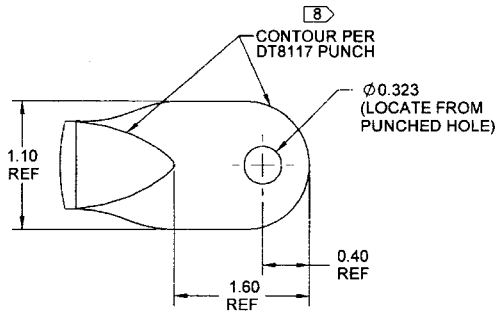
REV.	DESCRIPTION	BY	DATE
D	INCORPORATED C1,C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST.	AJS	08.05.08
C	REDRAWN, 0.386 WAS 0.375.	RF	99.06.07
B	-103 DELETED	JB	93.04.20
A	NEW ISSUE	JB	91.10.22

DESIGN	JB	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D2037 REV. D
MFG. APPR.		SHEET 1 OF 2
APPROVED		TITLE ARM SCALE NTS
DE APPR.		
DATE	08.05.08	

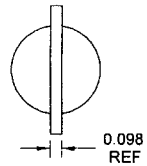
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D2037-101 ARM



DETAIL A
SCALE 2X
2 PL △D



RELEASED
08.07.07

DESIGN	JB	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2037	REV. D
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE ARM	SCALE NTS
DE APPR.			
DATE 08.05.08			

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DART AEROSPACE LTD

Description: Arm		**Work Order:**	109508
Inspection Drawing:	D2037	Rev: D	Part Number: D2037-107

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46.30	+/- .030	46.30	/		T	SA-5
45.50	+/- .030	45.50	/		T	SA-5
Ø.323	+/- .005	.323	/		J	SA-11

Measured by:	DAS 30 9-89	**Checked By:** FF	**QC inspector:** SM		**Engineering Approval** *(if necessary)*:
Date	13/12/16	**Date** 13-12-16	**Date** 13/12/16		**Date**